

48

Date: Tuesday, 11/13/2007 1:24:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (EC 135)
 Job Number : 35655
 Estimate Number : 10536
 P.O. Number : N/A Part Number : D135692011
 This Issue : 11/13/2007 S.O. No. : N/A Drawing Number : D3049 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1
 Previous Run : 32938 Material : N/A
 Due Date : 11/30/2007 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: C 04.02.17 Blank size changed, Tolerance added Step
 3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0

DC

DOCUMENT CONTROL



11/13/21

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

5 11/21

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 5.4810 sf(s)/Unit Total: 21.9240 sf(s)

blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)

per DSK086-9

Material: Black.UHMW 1"(MUHMWB10)

Batch: 1105863

DJP 11/29

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

DJP 11/30

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 11/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 35655

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JS 07/12/03 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.5000 f(s)/Unit Total: 2.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B060 Rubber Cushion

34777

No quantities

JS 07/12/03

(6)

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

B32057

JS 07/12/03

(X)

9.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519 Clamp

B26216

JS 07/12/03

(X3)

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer

B32025

JS 07/11/03

(X4)

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt

M104746

JS 07/12/03

(X4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 07/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:24:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 35655

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

8 AN960JD416 Washer M105906

MS 04/12/03

(x4)

13.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

8 MS21042L4 Nut (or -4) M105054

MS 04/12/03

(x4)

14.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

2 D3049-1(ref) Bearpaw 35655

4 QS100M24S Clamp M105568

1 Paperwork package from Step 2(ref)

MS 04/12/03

(x4)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

MS 04/12/04 (x4) (KITS)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location: C

PPP Rev: C

7/12/04 SQ (4x)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MS 04/12/04 (4)

Job Completion



MS 04/12/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35655
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0.260	✓			
B	0.93	+/-0.030	0.929	✓			
C	0.40	+0.030/-0.000	0.405	✓			
D	2.00	+/-0.030	2.005	✓			
E	10.250	+/-0.010	10.250	✓			
F	4.540	+/-0.030	4.545	✓			
G	5.88	+/-0.030	5.878	✓			
H	0.38	+/-0.030	0.379	✓			
I	15.50	+/-0.030	15.50	✓			
J	0.07 x 45°	+0.030/-0.010	0.07x45°	✓			
K	0.44 - 0.47	+/-0.000	0.440	✓			
L	R0.25	+/-0.030	0.250	✓			
M	0.38	+/-0.010	0.380	✓			
N	0.95	+0.030/-0.010	0.9425	✓			
O	0.69	+/-0.030	0.670	✓			
P	0.20	+/-0.030	0.191	✓			
Q	23.00	+/-0.030	23.00	✓			
R	0.25 x 45°	+/-0.030	0.25x45°	✓			

Measured by: DJP	Audited by: ml	Prototype Approval:	N/A
Date: 07/11/29	Date: 07/11/29	Date:	N/A

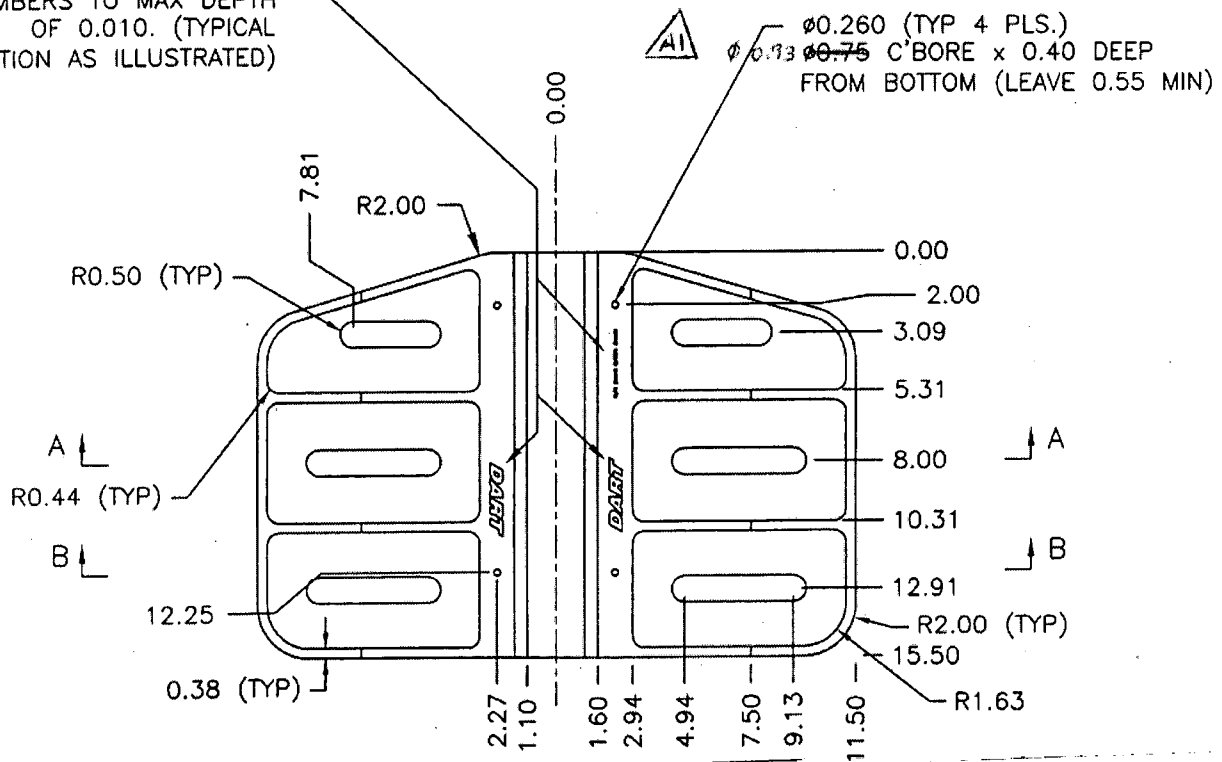
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	✱



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18	TITLE BEARPAW		SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	Ø 0.73 W 95 Ø 0.75	

RELEASED
01.10.24 #

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

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WITHOUT NOTICE
WORK ORDER
NO. 35655

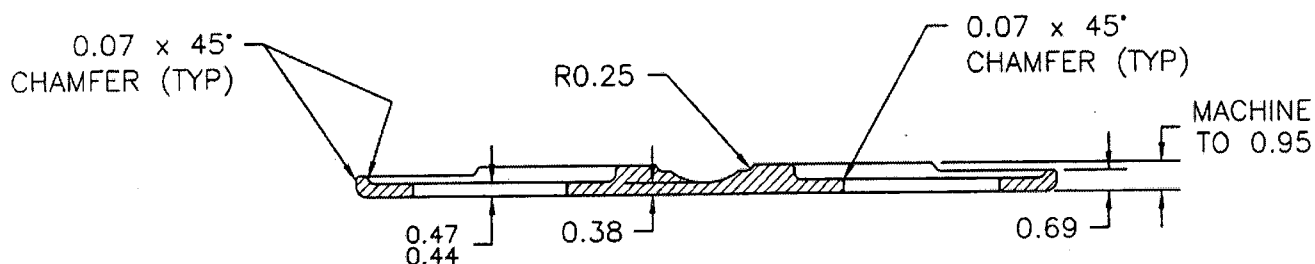
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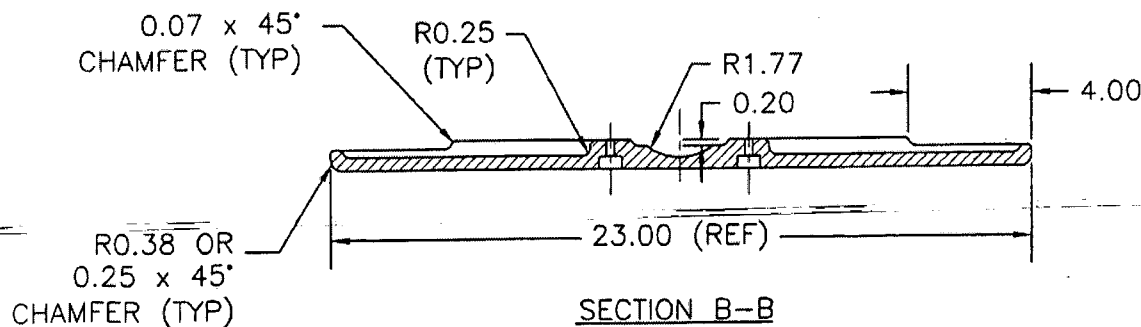


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H



SECTION A-A



SECTION B-B

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